



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

269T1338-11
Job Sheet 201305



Part No: 269T1338-11 **Job Qty:** 2 pcs

Part Name: Pitch Link Rigging Block



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/30/19

Job Tracking No:

Due Date: 12/5/19

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG 269T1338-11 Rev 4 IPP Rev A 18.02.12 New Issue FK Verify DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
115	Purchasing	2 pcs	12/5/19	12/5/19	0.00	0.00	Purchasing - 1		DEC 09 2019
							Purchasing - 2		
							Purchasing - 3		
116	Packaging 2-1 - Receive - B4B	2 pcs	12/5/19	12/5/19	0.00	0.00	Packaging 2 - 1 - B4B		DEC 09 2019
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 - B4B		
							Packaging 2 - 21 - B4B		
							Packaging 2 - 22 - B4B		
							Packaging 2 - 23 - B4B		
							Packaging 2 - 24 - B4B		
							Packaging 2 - 25 - B4B		
							Packaging 2 - 26 - B4B		
							Packaging 2 - 27 - B4B		
							Packaging 2 - 28 - B4B		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S238384



Part: 269T1338-11

Job No: 201305

Serial No/Batch: S238384

Revision: 4

Inspector:

Exp Date:

Instructions:

Date: 12/09/19

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					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
117	QC 6	2 pcs	12/5/19	0.00 0.00	QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	DAS
					QC 6 - 40	81
					QC 6 - 81	9-89
						DEC 11 2019
130	Packaging 3-1 - Stock - B4B	2 pcs	12/5/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
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					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140	QC 21 - FG	2 pcs	12/5/19	0.00 0.00	QC 21 - FG - 21	
					QC 21 - FG - 70	
					QC 21 - SA - 53	
						DAS
						21
						DEC 11 2019

Part Op 115 - -Issue P/O to ARROW TECH MACHINE WORKS ; P/O H2044651 -Manufacture 269T1338-11 as per DWG. -
 Descriptions: Certificate of Conformity is required

116 - (Pac2-Receive & Inspect for Damage & Mat'l Certs.)

117 - (QC6- All purchased or subcontracted products)

130 - (Identify as per dwg & Stock Location: _____) Identify and Stock

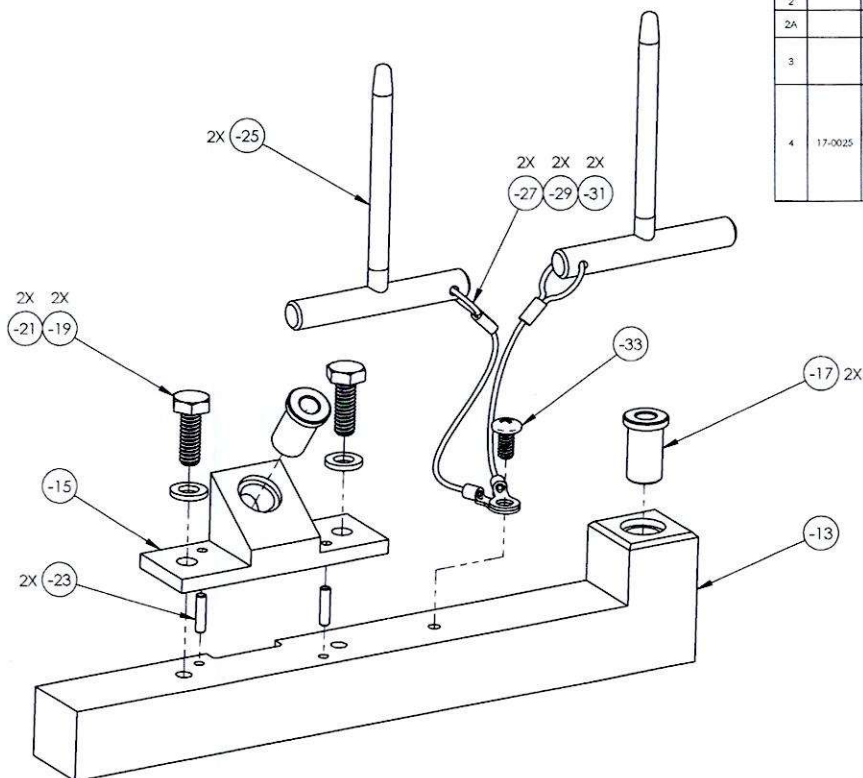
140 - (QC21- Final Inspection - Work Order Release)

x2 plus oct 01. 2019

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
269T1338-11P	Pitch Link Rigging Block	2 (1 ea)	115-Purchasing	S238381
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
115-Purchasing	269T1338-11P	2	0	0
Part Specifications				
Specifications could not be found.				

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
1		-15 LOCATOR HT., WAS 1.134.010, NOW 1.105+.005.	8/21/2009	WP
1A		CHD P/N -23 FROM ROLL PIN PER WP.	9/29/2009	RJC
2		CHD -25 1-PIN FROM BUY OUT TO BEING MACHINED @.2490 TO @.2485 PER DAVE. ADDED PAGE 2.	11/12/2009	WP
2A		CREATED SHEETS 3 & 4. MOVED COMPONENTS INTO SEPARATE SHEETS, REVISED BOM. ADDED NOTE 2, CHD -25 FINISH FROM BLACK OXIDE TO BLACK ZINC.	9/8/2011	SE
3		-13 DELETED R.062 IN BOTTOM OF CUTOUT. ADDED MISSING DIM 2X R.06. CHD DIM WAS 2X Ø.125 P.F. -23 B 2X LIMITS Ø.1244 TO .1249. -15 CHD DIM WAS 2X Ø.125 TO .1258. -19 ADDED B/O INFO #9045A761. -25 ADDED B/O INFO #98381A471. -27 ADDED B/O INFO #3897731. -33 ADDED B/O INFO #91400A240. CHD TOLERANCE ON NON-CRITICAL PARTS.	5/22/2014	DPD
4	17-0025	UPDATED TO NEW STANDARDS. DELETED NOTE 1 & 2. -13 CHD DIM WAS Ø.313 THRU L J Ø.563 Ø.094 S.F. -17 Ø.4380/Ø.4375 THRU P.F. -17 IS Ø.313 THRU ALL Ø.4380/Ø.4375 Ø.940 L J Ø.563 Ø.094 P.F. -17 WAS 2X 1/4-20 UNC THRU B 2X 1/4-20 UNC. -28 THRU ALL WAS Ø.1024 UNC. -28 Ø.63. REMOVED DIM 6.020. 1.123. 50. ADDED DIM 5.520. .625. 1.500. .250. -18 CHD DIM WAS .500 B 2X .500 WAS Ø.4380/Ø.4375 THRU P.F. -17 L J Ø.563 Ø.094 S.F. -17 IS Ø.4380/Ø.4375 THRU (P.F. -17) L J Ø.563 Ø.094 S.F. -17 WAS 35° B (35°). REMOVED DIM (.101). .175. .905. (.405). -23 CHD MATERIAL WAS S.S. IS STEEL. -25 CHD DIM WAS 3.0 B (3.0). CHD FINISH AND SPEC WAS BLACK ZINC. ASTM A633/AS. TYPE II. CLASS II B BLACK OXIDE Q1546.2.2. R.O. REV D. -27 CHD B/O INFO WAS 7-19 STRAND. Ø1/4 X 8 MCMASTER-CARR #8930752 IS Ø.062 X 8 (CARR LANE CL-2-C). -29 CHD B/O INFO WAS Ø1/32 MCMASTER-CARR # 8997731 IS ID.138 (CARR LANE # CL-2-F). -31 CHD B/O INFO WAS #10 B #10 (CARR LANE # CL-194-TERM).	1/30/2017	SM

NOTE:
WHEN PRESSING -17 INTO -15 USE MACHINING
FIXTURE FOR -15. MAKE SURE TO INSERT SHIM
STOCK INTO GAP TO KEEP FIXTURE FROM
COLLAPSING WHEN PRESSING BUSHING.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-13	1	BLOCK	6061		2
			-15	1	LOCATOR	6061		3
		B/O	-17	2	DRILL BUSHING	STEEL	Ø1/4 X 3/4 (MCMASTER-CARR # 8492A141)	1
		B/O	-19	2	HEX HEAD CAP SCREW	S.S.	1/4-20 X 3/4 (MCMASTER-CARR # 92240A540)	1
		B/O	-21	2	WASHER	S.S.	Ø1/4 I.D. (MCMASTER-CARR # 90945A761)	1
		B/O	-23	2	DOWEL PIN	STEEL	Ø1/8 X 1/2 (MCMASTER-CARR # 98381A471)	1
			-25	2	T-PIN	STEEL	Ø1/4 X 3 (MCMASTER-CARR # 98021A419) MODIFIED	4
		B/O	-27	2	COATED LANYARD CABLE	COATED STEEL	Ø.062 X 6 (CARR LANE CL-2-C)	1
		B/O	-29	2	FERRULE	METAL	ID.138 (CARR LANE # CL-2-F)	1
		B/O	-31	2	WIRE CRIMP EYELET	METAL	#10 (CARR LANE # CL-194-TERM)	1
		B/O	-33	1	MACHINE SCREW	S.S.	#10-24 X 3/8 (MCMASTER-CARR # 91400A240)	1

DART AEROSPACE																													
TITLE PITCH LINK RIGGING BLOCK ASSEMBLY																													
DWG NO. 269T1338-11	REV 4																												
<table border="1"> <tr> <td>MAT'L</td> <td>UNLESS OTHERWISE SPECIFIED</td> </tr> <tr> <td>FEAT</td> <td>DIMENSIONS ARE IN INCHES</td> </tr> <tr> <td>USE</td> <td>XXX ± .005 FRACTIONS ± 1/8</td> </tr> <tr> <td>FINISH</td> <td>.XX ± .01 ANGLES ± 5°</td> </tr> <tr> <td></td> <td>.X ± .1 SURFACES ± 125</td> </tr> <tr> <td>SPEC</td> <td>1. BREAK ALL SHARP EDGES .015 x 45° OR .015R</td> </tr> <tr> <td>DRAWN BY:</td> <td>PERRITT</td> </tr> <tr> <td>CHECKED:</td> <td>RJC 02/01/2017</td> </tr> <tr> <td>OPPS APPR:</td> <td>AA 02/06/2017</td> </tr> <tr> <td>QA APPR:</td> <td>JL 02/08/2017</td> </tr> <tr> <td>APPROVED:</td> <td>JAG 02/21/2017</td> </tr> <tr> <td>SCALE</td> <td>2:3</td> </tr> <tr> <td>DATE</td> <td>8/15/2007</td> </tr> <tr> <td>SHEET</td> <td>1 OF 4</td> </tr> </table>		MAT'L	UNLESS OTHERWISE SPECIFIED	FEAT	DIMENSIONS ARE IN INCHES	USE	XXX ± .005 FRACTIONS ± 1/8	FINISH	.XX ± .01 ANGLES ± 5°		.X ± .1 SURFACES ± 125	SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	DRAWN BY:	PERRITT	CHECKED:	RJC 02/01/2017	OPPS APPR:	AA 02/06/2017	QA APPR:	JL 02/08/2017	APPROVED:	JAG 02/21/2017	SCALE	2:3	DATE	8/15/2007	SHEET	1 OF 4
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044651



Supplier: ARR002-VU
Arrow Tech Machine Works
29751 E. Enid Road,
Unit C
Eugene, OR 97402 USA
Phone: 541-780-6938
Fax: 458-215-4938

Attention: , Ana
(541) 780-6938

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044651

PO Date: 10/1/19

Due Date: 12/5/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Pymt Terms: Net 30

Freight Terms:

Special Comments:

DFARS 252.225-7012 & DFARS 252.225-7015
raw material identification (as applicable). No
Raw Metals from China or Soviet Bloc
Countries

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	201305	269T1338-11P			Pitch Link Rigging Block REV 4	Firmed	-	12/5/19	2 Ea	0 Ea	2 Ea	\$1,206.00/Ea	\$2,412.00
Line Item Note Follow Drawing instruction , Please engrave " Made in USA "													
2	201306	RBA9937-5P			Tail Rotor Nut Wrench "C" Model (Rb Design) REV 4	Firmed	-	12/5/19	6 pcs	0 pcs	6 pcs	\$289.00/pcs	\$1,734.00
Line Item Note Follow Drawing instruction , Please engrave " Made in USA "													
3	201307	RB T102137-107P			Tool Lifting REV G	Firmed	-	12/5/19	8 pcs	0 pcs	8 pcs	\$925.68/pcs	\$7,405.44
Line Item Note *** LOAD TEST REQUIRE BEFORE DELIVERY ***													
4	201308	RB T102019P			Rigging Tool REV E	Firmed	-	12/5/19	12 pcs	0 pcs	12 pcs	\$399.50/pcs	\$4,794.00
5	201309	RBT400353p			Lateral Rigging Tool (407) REV B	Firmed	-	12/5/19	4 pcs	0 pcs	4 pcs	\$493.75/pcs	\$1,975.00
Line Item Note Follow Drawing instruction , Please engrave " Made in USA "													



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PURCHASE ORDER

POHB044651



Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
6	201310	RBT400354p			Longitudinal Rigging Tool (407) REV 1	Firmed X4	-	12/5/19	4 pcs	0 pcs	4 pcs	\$493.75/pcs	\$1,975.00
										DEC 09 2019			

Line Item Note Follow Drawing instruction , Please engrave
" Made in USA "

Grand Total: \$20,295.44

Order Notes

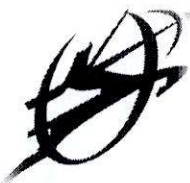
Procurement Quality Clauses
A005 RIGHT OF ENTRY
A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 10/1/19 11:53 AM dart.lussier.patrick



ARROW TECH MACHINE WORKS

Certificate of Conformance

Your Purchase Order No: HB044651 Dated: 12/4/2019

Our Order / Job No: AWT-HB044651 A1 Order Qty: 2

Part Name: PITCH LINK RIGGING BLOCK ASSEMBLY

Part Number 269T1338-11

Lot Size: N/A Ship Date: 12/4/2019

We certify that these parts shipped to you are of domestic or international manufacture and conform to all requirements of the Purchase Order. These parts have been manufactured and inspected in accordance with all required specifications, instructions and drawings. Any applicable specifications are listed below:

Drawing Number: 269T1338-11 Rev: 4

Material Size and Type: -13, -15/ 6061 ALUM.

Material Specifications: ALUM.: ASTM B221

Heat Treatment: N/A

Plating/Finish: BLACK ANODIZE: MIL—A-8625F, TYPE II, CLASS II; BLACK OXIDE: QMSI-6.2.2 B.O. REV-D

Mercury Contamination: The material used to process this order has not come in contact with mercury or mercury bearing instruments.

Date: 12/4/19

Signed: Hernan M. Labe

PHGE Machine Works LLC dba Arrow Tech Machine Works
29751 E. Enid Rd. Unit C Eugene, Oregon 97402
Main: (541) 780-6938 | Fax: (458) 215-4938
www.atechmachineworks.com



Packing Slip Number	7147
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Date: 12/4/2019

Ship Via: **FED-EX**

PO#:	HB044651
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Bill to: DART AEROSPACE
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

RECEIVED
DEC 09 2019
DART AEROSPACE LTD.

Page Number: